

Work Order ID 96067

Friday, January 18, 2013 10:30:36 AM

Page 1

Item ID: D4548-011

Revision ID:

Item Name: STD Flat Window Assembly, LH

Start Date: 1/18/2013 Start Qty: 1.00

Required Date: 1/31/2013 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *PL*Date: *13-01-18*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

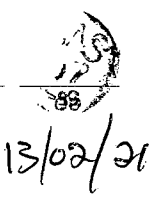
HAI ONLY
~~*96067*~~
N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4548	PA5								
120		0.00							
120	Pick Kit								
HandThermo		0.00							
Hand Finishing Thermoforming	Memo Pick required parts								
130		0.00							
130									
HandThermo		0.00							
Hand Finishing Thermoforming	Memo 1-Assemble window as per dwg 2-engrave part # and batch # as per dwg 3-wrap window using saran wrap								


13/02/21

Work Order ID 96067***96067***

Page 2

Friday, January 18, 2013 10:30:36 AM

Item ID: D4548-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: STD Flat Window Assembly, LH
Start Date: 1/18/2013 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/31/2013 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

04700
Feb
13-2-26

Picklist Print

Page 1

Friday, January 18, 2013 10:30:40 AM

Work Order ID: 96067

96067

Parent Item: D4548-011

D4548-011

Parent Item Name: STD Flat Window Assembly, LH

Start Date: 1/18/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 13/01/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

BSP46

Purchased

No

120

Each

300.0000

1

1

RSP46

**

Commercial rivet

Location

Loc Qty

Loc Code

ST283

300

112540

300

D3802-1-120

Manufactured

No

120

Each

4.0000

1

1

D3802-1-120

**

Window Seal

Location

Loc Qty

Loc Code

ST408

4

68167

1

80437

2

92202

1

D4537-1

Manufactured

No

120

Each

0.0000

1

1

D4537-1

**

Flat Window, LH

D4550-099

Manufactured

No

120

Each

0.0000

1

1

D4550-099

**

Window Pile

D4551-1

Manufactured

No

120

Each

0.0000

1

1

D4551-1

**

Inboard Sliding Window Frame, LH

D4553-0928

Manufactured

No

120

Each

0.0000

1

1

D4553-0928

**

Window Track

-093

B80793

pulled on

H91

B80997

B 96324

1040

13/02/21

245

13/02/21

13/02/21

13/02/21

0776

Picklist Print

Page 2

Friday, January 18, 2013 10:30:40 AM

Work Order ID: 96067

96067

Parent Item: D4548-011

D4548-011

Parent Item Name: STD Flat Window Assembly, LH

Start Date: 1/18/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

D4553-1607	Manufactured	No	120	Each	0.0000	1	1	
D4553-1607								
Window Track								
D4553-2094	Manufactured	No	120	Each	0.0000	14	14	
D4553-2094								
Window Track								
D4554-1	Manufactured	No	120	Each	0.0000	1	1	
D4554-1								
Outboard Sliding Window Frame, LH								
NAS1149FN432P	Purchased	No	120	Each	192.0000	14	14	
NAS1149FN432P								
Washer								

Location

Loc Qty

Loc Code

ST294

192

120306

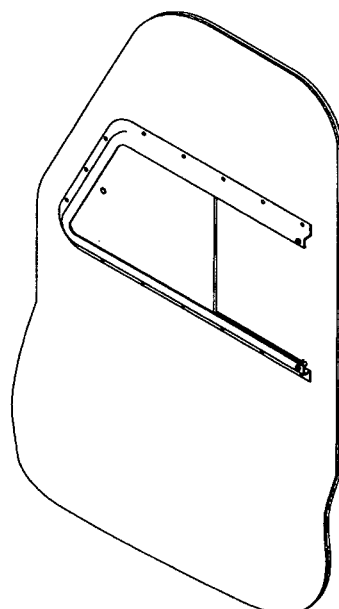
192

14

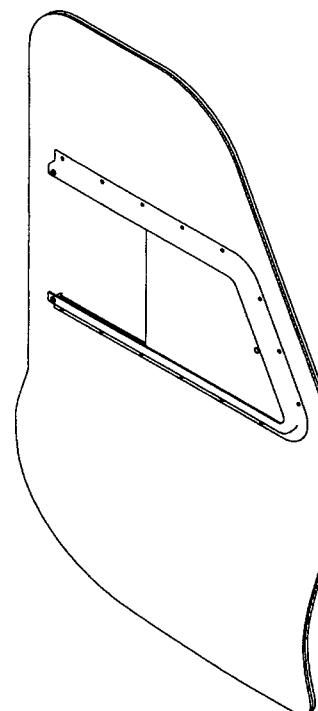
Friday, January 18, 2013 10:30:40 AM

Shop Packet Print

Page 2



D4548-041 STD FLAT CREW WINDOW (LH)



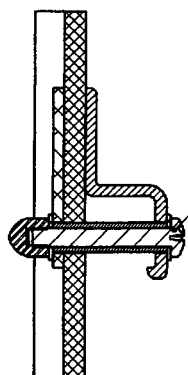
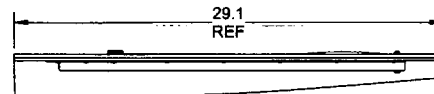
D4548-042 STD FLAT CREW WINDOW (RH)

*96067
R113-01-18*

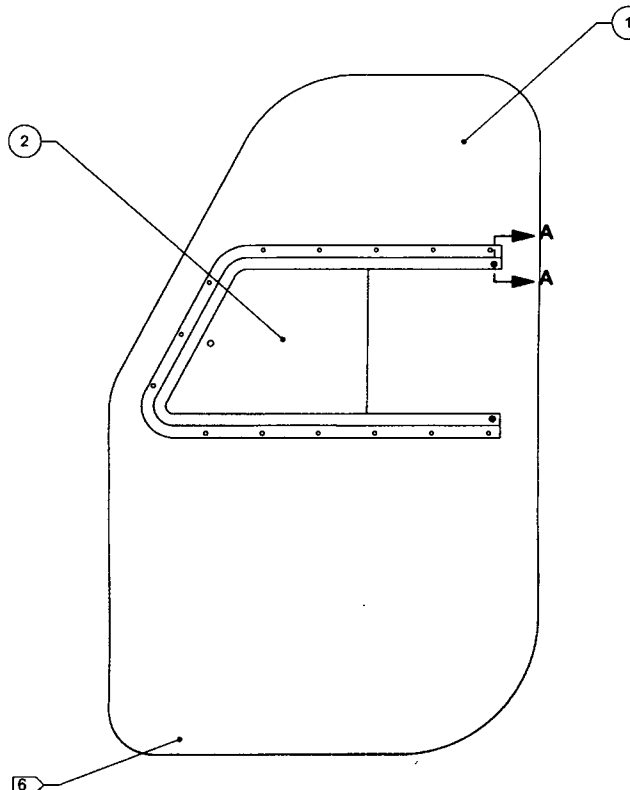
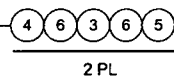
RELEASED
2012-03-08
MD

A		NEW ISSUE		AP	12.02.27
REV.		DESCRIPTION		BY	DATE
DESIGN		AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		AP			
CHECKED		<i>[Signature]</i>	DRAWING NO. D4548		REV. A
MFG. APPR.		<i>[Signature]</i>	TITLE		SHEET 1 OF 7
APPROVED		<i>[Signature]</i>	STD FLAT CREW WINDOW		SCALE
DE APPR.		<i>[Signature]</i>	NTS		
DATE	12.02.27		<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

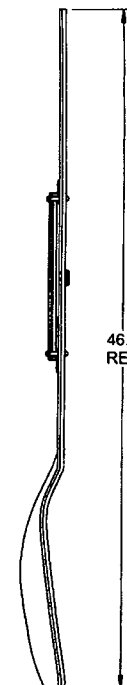
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4548-041	STD FLAT CREW WINDOW (LH)
1	1	D4548-011	FLAT WINDOW ASSY (LH)
2	1	D4552-041	SLIDING WINDOW ASSY (LH)
3	2	D4601-1	SPACER
4	2	MS27039-0818	SCREW
5	2	MS51865-4C	ACORN NUT
6	4	NAS1149CN832R	WASHER



SECTION A-A C3-2
SCALE 8X



D4548-041 STD FLAT CREW WINDOW (LH)



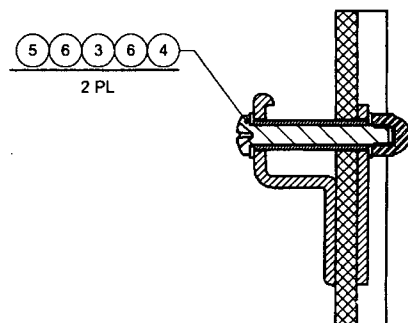
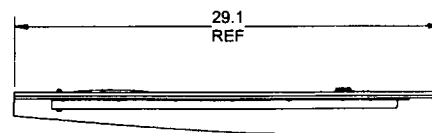
96061

RELEASED
2012-03-08

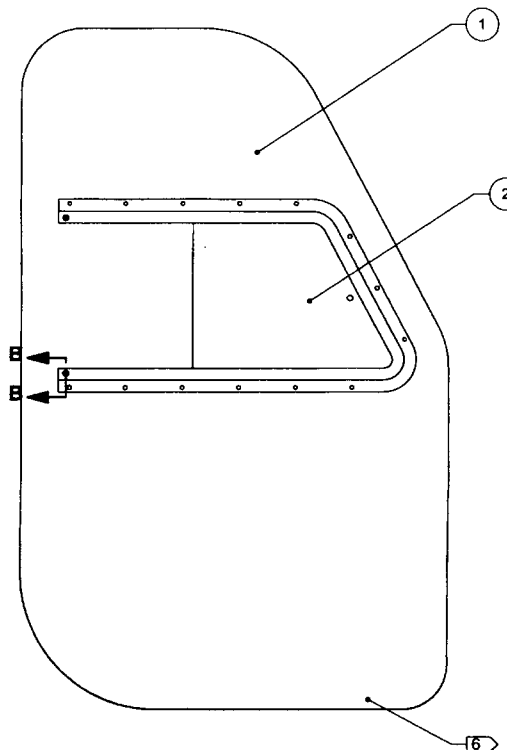
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4548-041" & BN "BXXXXX" WITHIN 0.125 IN FROM THE EDGE OF WINDOW, USE .125" LETTERS TO MAX DEPTH OF 0.005 PER DART QSI 044 6.4 USING VIBRATING STYLUS
 - 7) WEIGHT: 12.0 lbs

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4548	SHEET 2 OF 7
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	STD FLAT CREW WINDOW	NTS
DATE	12.02.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

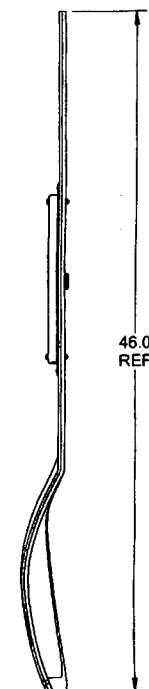
ITEM	QTY -042	P/N	DESCRIPTION
	X	D4548-042	STD FLAT CREW WINDOW (RH)
1	1	D4548-012	FLAT WINDOW ASSY (RH)
2	1	D4552-042	SLIDING WINDOW ASSY (RH)
3	2	D4601-1	SPACER
4	2	MS27039-0818	SCREW
5	2	MS51865-4C	ACORN NUT
6	4	NAS1149CN832R	WASHER



SECTION B-B C5-3
SCALE 8X



D4548-042 STD FLAT CREW WINDOW (RH)



96061

RELEASED
2012-03-08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4548-042" & BN "BXXXXX" WITHIN 0.125 IN FROM THE EDGE OF WINDOW, USE .125" LETTERS TO MAX DEPTH OF 0.005 PER DART QSI 044 6.4 USING VIBRATING STYLUS
- 7) WEIGHT: 12.0 lbs

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4548	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STD FLAT CREW WINDOW	NTS
DATE	12.02.27	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

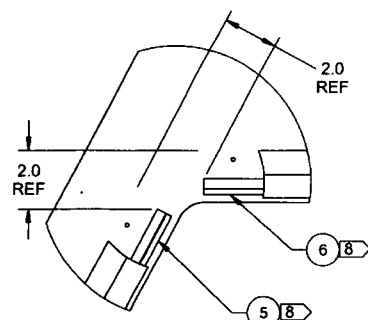
ITEM	QTY -011	P/N	DESCRIPTION
	X	D4548-011	FLAT WINDOW ASSY (LH)
1	1	D3802-1-100	WINDOW SEAL
2	1	D4537-1	FLAT WINDOW (LH)
3	1	D4550-097	WINDOW PILE
4	1	D4551-1	INBOARD SLIDING WINDOW FRAME
5	1	D4553-093	WINDOW TRACK
6	1	D4553-161	WINDOW TRACK
7	1	D4553-209	WINDOW TRACK
8	1	D4554-1	OUTBOARD SLIDING WINDOW FRAME (LH)
9	14	BSP-46	RIVET
10	14	NAS1149FN432P	WASHER

D

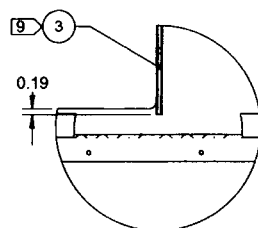
C

B

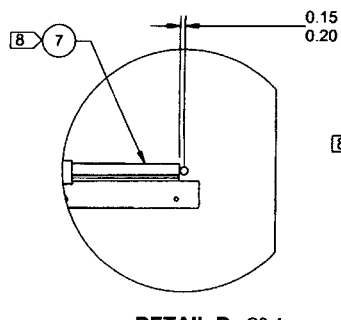
A



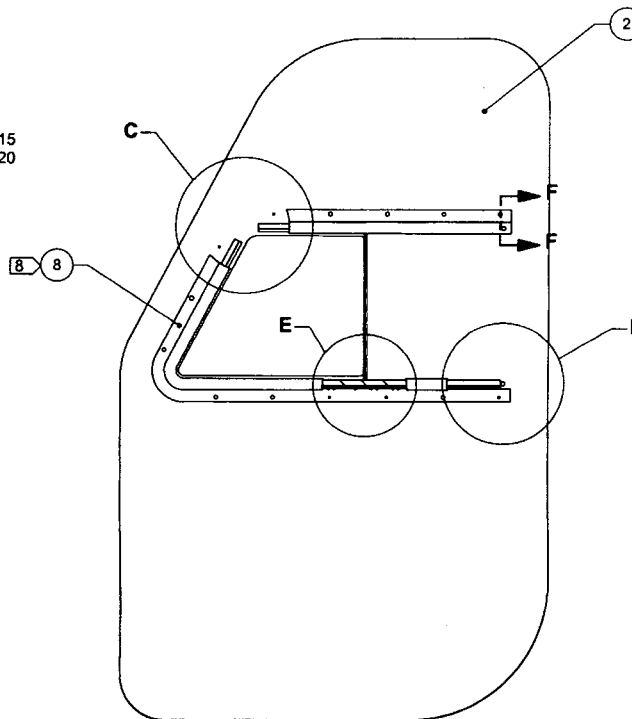
DETAIL C
SCALE 2X



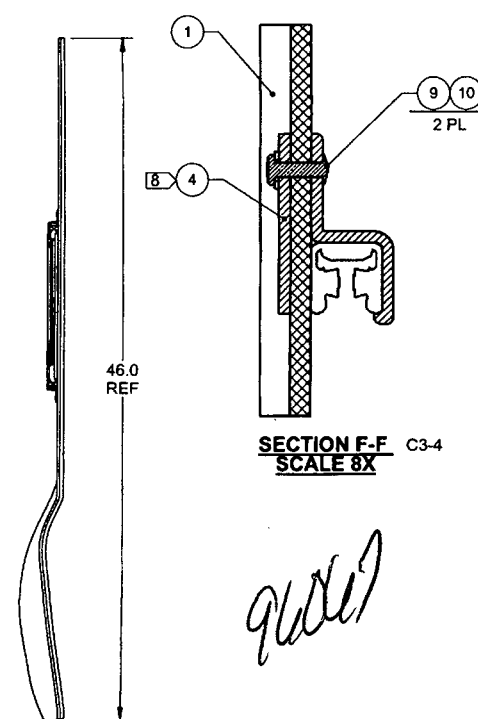
DETAIL E
SCALE 2X



DETAIL D
SCALE 2X



D4548-011 FLAT WINDOW ASSY (LH)



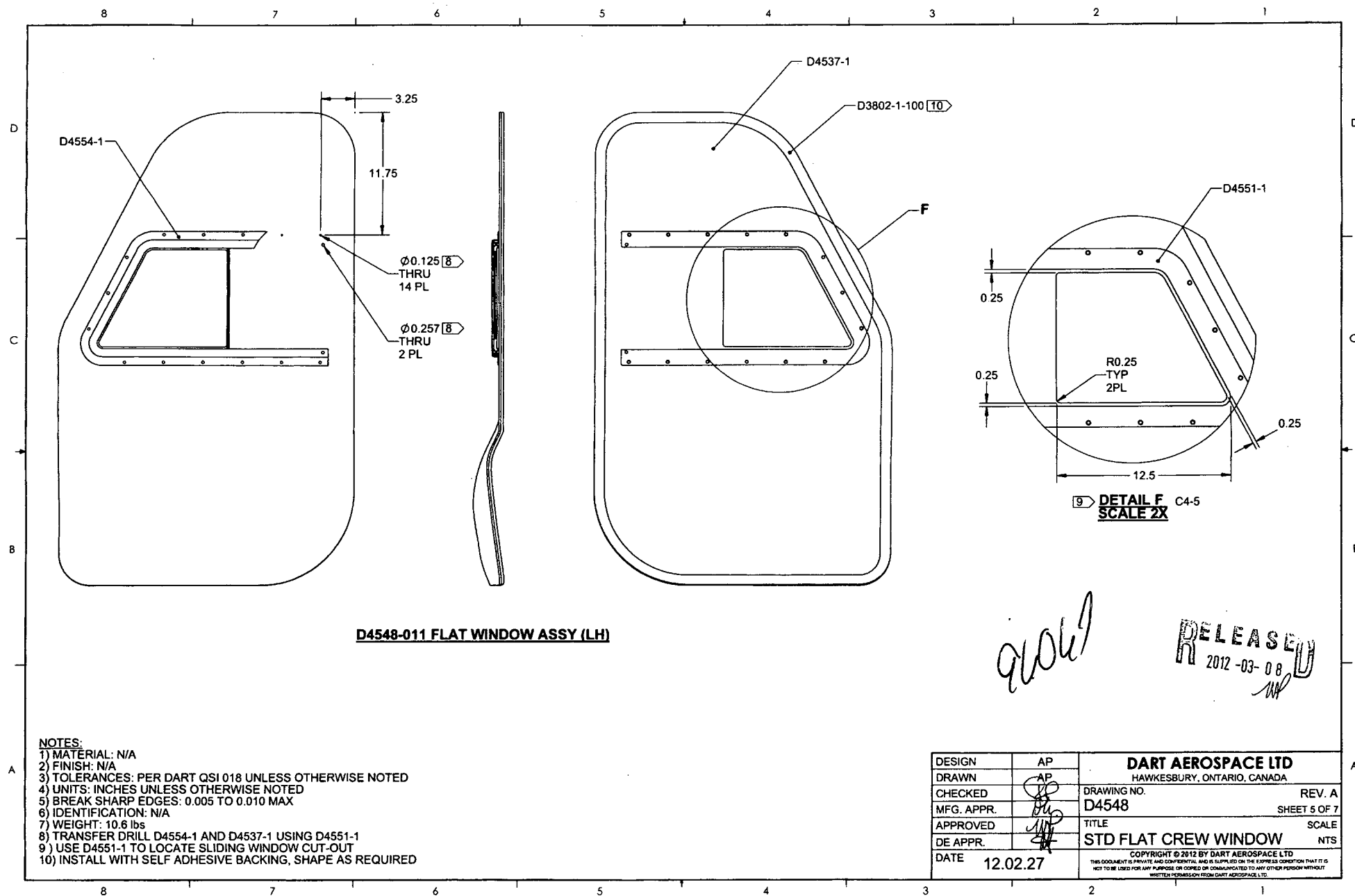
SECTION F-F
SCALE 8X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 10.6 lbs
- 8) INSTALL WITH BLACK SIKAFLEX
- 9) INSTALL WITH 3M SCOTCH-WELD 1300L RUBBER & GASKET ADHESIVE

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4548	SHEET 4 OF 7
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	STD FLAT CREW WINDOW	NTS
DATE	12.02.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

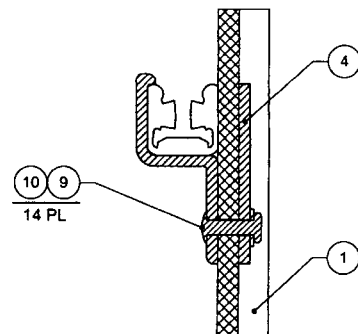
RELEASED
2012-03-08



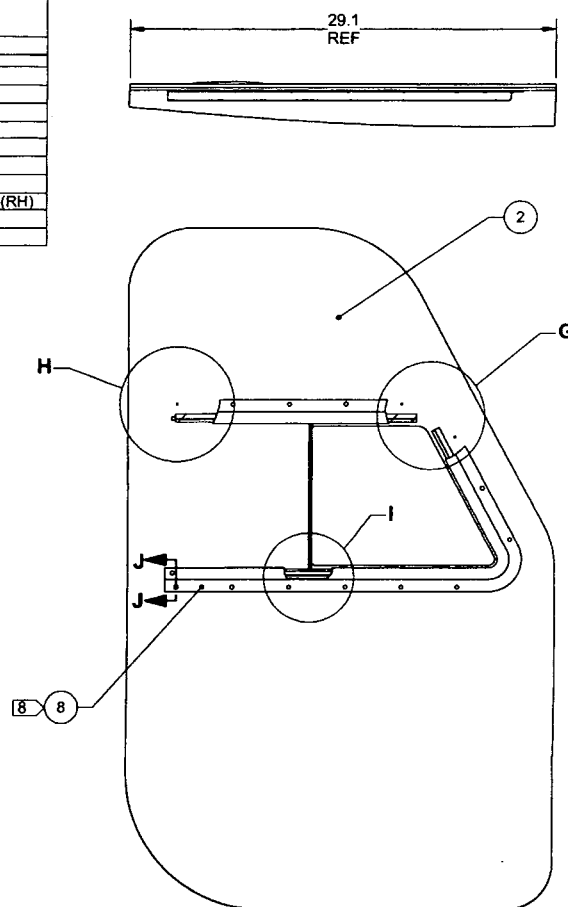
glove

RELEASED
 2012-03-08

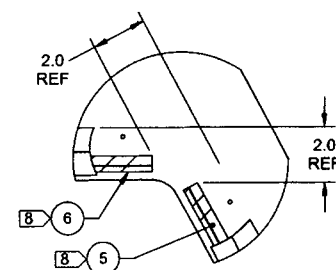
ITEM	QTY -012	P/N	DESCRIPTION
	X	D4548-012	FLAT WINDOW ASSY (RH)
1	1	D3802-1-100	WINDOW SEAL
2	1	D4537-2	FLAT WINDOW (RH)
3	1	D4550-097	WINDOW PILE
4	1	D4551-1	INBOARD SLIDING WINDOW FRAME
5	1	D4553-093	WINDOW TRACK
6	1	D4553-161	WINDOW TRACK
7	1	D4553-209	WINDOW TRACK
8	1	D4554-2	OUTBOARD SLIDING WINDOW FRAME (RH)
9	14	BSP-46	RIVET
10	14	NAS1149FN432P	WASHER



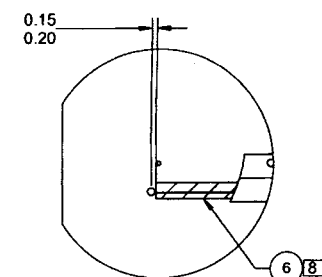
**SECTION J-J C5-6
SCALE 8X**



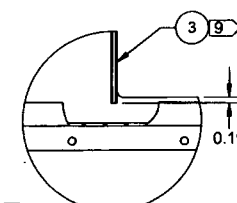
D4548-012 FLAT WINDOW ASSY (RH)



**DETAIL G C4-6
SCALE 2X**




**DETAIL H C5-6
SCALE 2X**

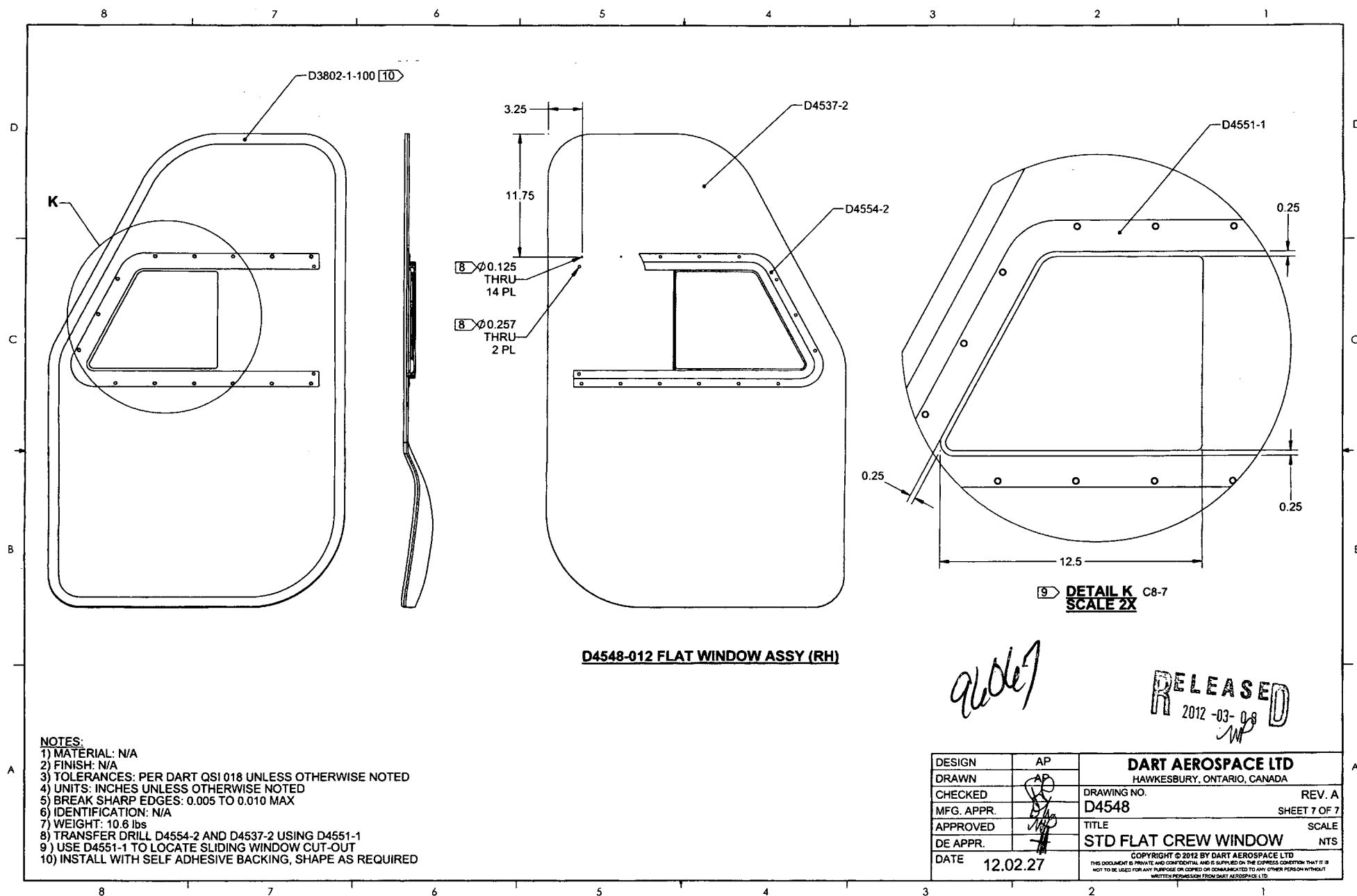


**DETAIL I C5-6
SCALE 2X**

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 10.6 lbs
 - 8) INSTALL WITH BLACK SIKAFLEX
 - 9) INSTALL WITH 3M SCOTCH-WELD 1300L RUBBER & GASKET ADHESIVE

RELEASED
2012-03-08

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4548	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		STD FLAT CREW WINDOW	NTS
DATE	12.02.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4548	SHEET 7 OF 7
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	STD FLAT CREW WINDOW	NTS
DATE	12.02.27	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2012-03-08